

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000671**Date Inspected:** 19-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Meter Mock-Up**Summary of Items Observed:**

Tower Mock Up

This QA Inspector observed ZPMC welder Wang Zhong Hua, welder identification 053753 welding in the flat groove weld position flat (1G) on the 89 Meter Mock-Up, MUB MA-21 on weld joints 9A and 9B. Welding was being carried out to welding procedure specification (WPS) WPS-B-T-3212-TC-U5B using the Shield Metal Arc Welding (SMAW) process with 9018M-H4R electrode. The essential variables were checked by the Quality Control (QC) Inspector and the voltage was found to be 22.7, the amperage 243 and the travel speed 152 mm per minute. Preheat was measured and found to be 176 degrees Celsius (C). The ZPMC Certified Welding Inspector (CWI), Sha Zhi was on hand witnessing the welding.

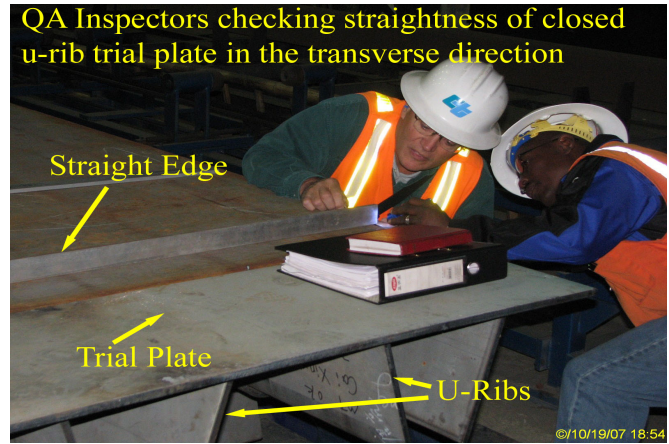
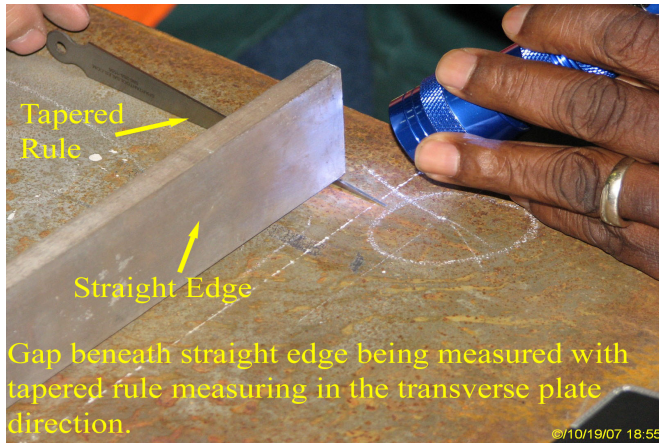
This QA Inspector observed that ZPMC personnel were fitting and tack welding the Diaphragm Edge Plate for the 89 Meter Top Diaphragm Plate into place.

OBG Mock Up

QA Inspectors performed longitudinal and transverse straightness measurements on the closed u-rib weld trial.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer